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D3915-041
Job Sheet 175333



Part No: D3915-041

Job Qty: 1 ea

Part Name: Light Lid Assembly, Long Basket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/3/18

Job Tracking No:

Due Date: 4/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV F SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/19/18	4/19/18	0.00	0.00	Start Up Large Fab-5		20-2018-04-04
100	Large Fab	1 pcs	4/19/18	4/19/18	0.00	3.33	Large Fab 2		11-18-4-5
110	QC	1 pcs	4/19/18	4/19/18	0.00	0.00	QC9		PD 13-4-6
120	QC	1 pcs	4/19/18	4/19/18	0.00	0.00	QC5		PD 13-4-6
130	HandFinish	1 pcs	4/19/18	4/19/18	0.00	1.00	HandFinish1		SA 18-04-09
140	Large Fab	1 pcs	4/19/18	4/19/18	0.00	3.33	Large Fab 2		SA 2018-04-12
150	QC	1 pcs	4/19/18	4/19/18	0.00	0.00	QC9		CPC
155	QC	1 pcs	4/19/18	4/19/18	0.00	0.00	QC5		CPC
157	HandFinish	1 pcs	4/19/18	4/19/18	0.00	1.00	HandFinish1		BEB 18-04-25
160	Powdercoat	1 pcs	4/19/18	4/19/18	0.00	0.83	Powdercoat1		BR/ BEB 18-04-26
170	QC	1 pcs	4/19/18	4/19/18	0.00	0.00	QC3		M 18-4-30
180	HandFinish	1 pcs	4/20/18	4/20/18	0.00	0.81	HandFinish4		
190	QC	1 pcs	4/20/18	4/20/18	0.00	0.00	QC5		
200	Packaging	1 pcs	4/20/18	4/20/18	0.00	0.00	Packaging3-2		
210	QC21-SA	1 Ea	4/20/18	4/20/18	0.00	0.00	QC21		

Part Op 100 - 1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make Descriptions: a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915
 120 - -Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4
 130 - ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***
 140 - 1- weld (4) corners
 155 - ***inspect fit of lid with base***
 157 - 1- realodine corners ***do not acid etch***
 160 - 1- touch up corner with alodine only 2- Plug holes prior to finish 3-Mask this area prior to finish View B-B 1ST COAT:
 START TIME: 11:20 OVEN TEMPERATURE: 320° FINISH TIME: 11:50 ***** 2nd
 coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 180 - 1- Install webbing as per dwg 2- Install placard and label as per dwg

M138760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2957	Mounting Plate	4 Ea (4 ea)	90-Start up Operation	138993
D3915-1	Rib	2 Ea (2 ea)	90-Start up Operation	3043184
D4016-5	Hinge Half, Light Lid	3 Ea (3 ea)	90-Start up Operation	3039258
D4019-3	Rib	3 Ea (3 ea)	90-Start up Operation	162731 (Q) 3043757 (Q)
D4035-047	Lid Rib Assembly, Aft (Light)	2 Ea (2 ea)	90-Start up Operation	3043729
D4056-1	Label Plate	1 Ea (1 ea)	90-Start up Operation	157507
D2728-1	Dart Logo Label Small	1 Ea (1 ea)	180-HandFinish	
D4029-041	Webbing (Long Basket)	1 Ea (1 ea)	180-HandFinish	
MS20600-AD4W4	Rivet	34 Ea (34 ea)	180-HandFinish	5848405
NAS1149DN949J	Washer	34 Ea (34 ea)	180-HandFinish	FMI 138246

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2957	4	4	0
	D3915-1	2	4	0
	D4016-5	3	46	0
	D4019-3	3	6	0
	D4035-047	2	2	0
	D4056-1	1	4	0
180-HandFinish	D2728-1	1	0	0
	D4029-041	1	0	0
	MS20600-AD4W4	34	1,507	0
	NAS1149DN949J	34	224	0

Part Specifications

Specifications could not be found.

Plex 4/3/18 10:09 AM Dart.Gagnon.Michelle



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Container No: S058106



Part: D3915-041

Job No: 175333

Serial No/Batch: S058106

Revision: F

Inspector:

Date: 04/04/08

Master Unit 002213



Job No

175333

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : <u>18-05-29</u>	Step #: <u>180</u>	QTY Effective : <u>1</u>		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		<u>PD 18-05-29</u> Completed By	
Webbing D4029-041 had to be remove (see NCR18-6845). therefore holes were enlarge when removing rivets, also rivet stem was left inside		Scrap destroy D3915-041		Lead hand / Supervisor Approval Verification	
				<u>PD 18-05-31</u>	
				QC / QA Coordinator Approval <u>PD 18-05-31</u>	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ ☒ Process Improvement Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ ☒ Fit/Function Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					